



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4880-1

Job Sheet 183452



Part No: D4880-1

Job Qty: 10 ea

Part Name: Strut



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Machining-3		
100	Doosan	10 pcs	10/12/18	10/12/18	0.20	14.71	Doosan		
110	QC	10 pcs	10/12/18	10/12/18	0.00	0.00	QC2 Machining-3		
120	QC	10 pcs	10/12/18	10/12/18	0.00	0.00	QC8 Machining-3		
130	Outsource	10 pcs	10/12/18	10/12/18			SKY002-VC	2	
140	Packaging	10 pcs	10/12/18	10/12/18	0.00	0.00	Packaging2		
150	QC	10 pcs	10/12/18	10/12/18	0.00	0.00	QC5		
160	Packaging	10 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3-2		
170	QC21-SA	10 Ea	10/12/18	10/12/18	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R0.750	17-4 SS H900 Round Bar 0.750"	7.6000 (76 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R0.750	8	18	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Strut	1.410Inches ± 0.030	1.440 1.380	1.408	
2	Strut	0.672Inches + 0.001 - 0.000	0.673 0.672	0.6724	
3	Strut	0.625Inches + 0.008 - 0.001	0.633 0.624	0.6255 Reamer	
4	Strut	0.430Inches ± 0.030	0.460 0.400	0.428	
5	Strut	0.500Inches ± 0.010	0.510 0.490	0.499	
6	Strut	7.751Inches ± 0.005	7.756 7.746	7.750	
7	Strut	9.110Inches ± 0.030	9.140	9.108 9.105	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

8	Strut		9.080
		0.125Inches + 0.004	0.129
		- 0.001	0.124

•127

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		Part No. _____		NCR No. _____		Date : _____		Step #: _____		Description Work Order Dev _____																																																																																																																																																									
Engineering ☐ Quality ☐ Other ☐ IB (QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																																																																																																																			
Part: D4880-1 Job No: 183452 Serial No/Batch: S118087 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 10/14/18 Container No: S118087 1270 Aberdeen Street Haverhill, MA 01830 Tel: 978.325.5200 Email: sales@darco.com www.darco.com																																																																																																																																																																			
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041413**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041413
PO Date: 10/22/18
Due Date: 10/29/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183762	D4881-1	Strut : Various STC's Outsource process - NDT per QSI038 4.1 ISSUE P/O : _____ C OF C IS REQUIRED	Firmed	-	10/29/18	10 pcs	0 pcs	10 pcs	\$11.00/pcs	\$110.00
2	184458	D4928-1	Strut : Various STC's LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)	Firmed	-	10/29/18	10 pcs	0 pcs	10 pcs	\$11.00/pcs	\$110.00
3	183452	D4880-1	Strut LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)	Firmed	-	10/29/18	10 pcs	0 pcs	10 pcs	\$11.00/pcs	\$110.00
4	183306	D4881-1	Strut : Various STC's Outsource process - NDT per QSI038 4.1 ISSUE P/O : _____ C OF C IS REQUIRED	Firmed	-	10/29/18	8 pcs	0 pcs	8 pcs	\$11.00/pcs	\$88.00
Grand Total:											\$418.00

DAC
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9-89

[Handwritten signature]



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041413

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/29/18 8:41 AM dart.tsimiklis.chrisoula

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO37951	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO41413 ✓
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 38 MISC PART.

ITEM ID: D4881-1 STRUT ✓

1 - WORK ORDER ID#: 183762 (QTY 10) ✓

ITEM ID: D4928-1 STRUT ✓

2 - WORK ORDER ID#: 184458 (QTY 10) ✓

ITEM ID: D4880-1 STRUT ✓

3 - WORK ORDER ID#: 183452 (QTY 10) ✓

ITEM ID: D4881-1 STRUT ✓

4- WORK ORDER ID#: 183306 (QTY 8) ✓

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-4) AS PER ASTM1417M-13						OCT 26 2018	DOT-APP 61 --89
NO CRACK FOUND							
Pen: ZL-27A MWO5678 DEV: SKD-S2 MPO11715 CLEANER: SKC-S MPO13923							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

DAC
38
9-89

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp DOT-APP 61 --89	Date:
Name: ANTONINO MARCHETTI		OCT 26 2018

